Al- - 500

Work Order Wednesday, May			Jal											Page	1 .
Item ID: I	D3490-1		101	A	Accept						Setup	Start			····
Item Name:	Cross Bolt Sp	acer										Stop			
Start Date: 5 Required Date: 5 Reference:	//11/2011 //13/2011	Start Qty: 60. Req'd Qty: 60.					Item I omer:	ID:							
Approvals:	Process Pla	an. il	Date:	1511	Tooling:		D.	ate:			Run	Start			
• -	QC:		Date:		SPC (Y/N):			ate:				Stop			
Sequence ID/ Work Center ID		Operation Description			Set Up/ Run Hours	Too	oł ID	Tool #	Plan Code	Accept Qty	t Rej Qty	•	Reject Number	Insp. Stamp	
Draw Nbr	Rev	ision Nbr													
D3490	Rev	A													
100		Hardinge CNC LAT	THE SMALL		0.00					64					
Hardinge CNC Lathe S	Small	FOLIO DWG I	N AS PER FOLIO REV:	31	3 D3490	Tie				- /	ţ				
110 		QC2- Inspect parts	off machine FAI/F/	AIB	0.00					64	8				_
Quality Control		AZCIIV		5	100/	19				`					
120	,	QC8- Inspect parts	- second check		0.00		•	፡ ዋ		Af					
QC Ouality Control		Memo			0.00	9 11. 9	•	· (*	

	•	·	34	ORK ORDER OUANOE	<u> </u>				
W/O:				ORK ORDER CHANGE			_	Approval	Annroyal
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Chief Eng / Prod Mgr	Approval QC Inspector
							_	•	
								7	
					,				
		·						,	
Part No) :	PAR #:	Fault Cat	egory:	NCR: Yes I	No DQA	\ :	Date:	
		esolution:							
NCR:		1	WORK OR	DER NON-CONFORMA	NCE (NCR)			
		Description of NC		Corrective Action Section		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector
							•		
				,					
									,

Work Order ID 69510

Wednesday, May 11, 2011 2:17:23 PM



Page 2

Item ID:

D3490-1

Accept

Setup Start

Stop



Revision ID:

Item Name:

Cross Bolt Spacer

Start Date: 5/11/2011

Start Oty: 60.00

Required Date: 5/13/2011

Req'd Qty: 60.00



Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Reject

Qty

Start



QC:

Date:

STOCK IN SKIDTUBE CELL

SPC (Y/N):

Date:

Stop

Reject

Number

Sequence ID/ Work Center ID

130

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

Memo

Set Up/ **Run Hours**

0.00

0.00

Tool # Plan

Code

Accept

Qty

Insp.

Stamp

140

QC21- Final Inspection - Work Order Release

0.00



Quality Control

Memo

0.00

	-							
W/O:			W	ORK ORDER CHANG	ES			
DATE	STEP	PROC	EDURE CH	ANGE	Ву	Date Q	ty Approval Chief Eng / Prod Mgr	Approval QC Inspector
							Frod Nigi	
Part No	•	PAR #:	_ Fault Cat	egory:	_ NCR: Yes	No DQA : _	Date: _	
	R	esolution:	_ Dispositi	on:	_ QA: N/C Cld	sed:	Date: _	
NCR:		W	ORK ORE	DER NON-CONFORMA	NCE (NCR)		
DATE	0750	Description of NC		Corrective Action Section		Verification	on Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		QC Inspector
-								
					1			1

Picklist Print

Wednesday, May 11, 2011 2:17:29 PM

Work Order ID: 69510

Parent Item:

D3490-1

Parent Item Name: Cross Bolt Spacer



Start Date: 5/11/2011

Required Date: 5/13/2011

Page 1

Start Qty: 60.00

Required Qty: 60.00

Comments:

1PP Rev:A New Issue 06-03-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.500W.049		Purchased	No			100	f	365.6670	0.266	16.8			
										SA	$\langle a \rangle$	S/1	9

6061-T6 RD Tube .500 x.049W

Location MAT014

Loc Qty 365.667 365.667 Loc Code

_	<u> </u>									
W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PRO	CEDURE CH	ANGE	,	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	egory:	_ NCF	R: Yes 1	10 DQ	A:	_ Date: _	
	R	esolution:	Disposition	on:	QA:	N/C Clo	sed:		Date: _	
NCR:		V	VORK ORE	ER NON-CONFORMA	ANCE	(NCR)				
DATE	STEP	Description of NC			ion B		Verifi	cation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Sect	ion C	Chief Eng	QC Inspector
				,	>					
			·						·	
					•					
		,								

DART AEROSPACE LTD	Work Order:	69510
Description: Crossbolt Spacer	Part Number:	D3490-1
Inspection Dwg: D3490 Rev: A		Page 1 of 1

	FIRS	ARTICLE	NSPECII	ON CHE	CKLIST		
		X First Arti	cle	Prot	otype		
Drawing Dimension	Tolerance	Actual Pimension	Accept	Reject	Method of Inspection	Соп	nments
Ø0.500	+0.006/-0.001	\$,500			P-18		
0.049	+/-0.010	840			•		
Ø0.402	+0.006/-0.001	0.405					
3.085	+0.030/-0.000	3.100	/				
0.050 x 45°	+/-0.010	050×75°					74
		·					
							-
				•			
				1			
~~							

		J	1	<u> </u>			
Measured by:	5/1	Audited by:	20		Prototype Appi	roval:	N/A
Date:	11/05/19	Date:	11.8	-19		Date:	N/A

	\		_		
Measured by:		Audited by:		Prototype Approval:	N/A
Date:	105/19	Date: 11. 8-19	1	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	06.10.06	New Issue	KJ/JLM	
В	08.06.02	Dimensions and tolerances revised	KJ/DD 1.0	
С	08.10.07	0.050 x 45° dimension revised	KJ/DD of	18

W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		÷							
Part No		PAR #:							
	Re	esolution:	Disposition	:	_ QA: N/C Cld	sed:		Date: _	
NCR:		,	WORK ORDE	R NON-CONFORM	ANCE (NCR)			_
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Sect Action Description Chief Eng	ion B Sign & Date		cation ion C	Approval Chief Eng	Approval QC Inspector
				<u> </u>					
									·

H:\fFÓRMS\Quality Assurance\approved QA\NCRWO RevE



SHOP COPY RETURN TO ENGINEERING

DESIGN PH	DRAWN BY	DART	AEROSPACE PORT HADLOCK,	
CHECKED	- APPROVED	DRAWING NO. D3490		REV. A SHEET 1 OF 1
DATE	<u> </u>	TITLE		SCALE
06.01.04		CROSS B	OLT SPACER	NTS

D3490-1/-3/-5 CROSS BOLT SPACER PARTS LIST

PART NUMBER	OD	WALL	ID (REF)	MATERIAL SPEC
D3490-1	0.500	0.049	0.402	M6061T6T0.500W.049
D3490-3	0.750	0.080	0.591	M6061T6R0.750
D3490-5	0.313	0.058	0.197	M6061T6T0.313W.058

D3490-1/-3/-5 CROSS BOLT SPACER

- 1) MATERIAL: ALUMINUM 6061-T6 (QQ-A-200/8 OR QQ-A-225/8)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



Copyright @ 2006 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

W/O:		WORK ORDER CHANGES							
DATE	STEP	PRO	OCEDURE CHAN			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		-							
,									
Part No:		PAR #:	Fault Categ	NCR: Yes	NCR: Yes No DQA: Date:				
	R	esolution:	Disposition	QA: N/C C	Closed: Date:				
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification		Approval	Approval
			Initial Chief Eng	Action Description Chief Eng	Sign Date		ion C	Chief Eng	QC Inspector
		_							
									_
_									

^{*} H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE